

Work Order ID 64106

November 24, 2010 12:43:00 PM



Page 1

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 11/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: C2 Date: 10/11/24 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3910	B

100 0.00



Bandsaw
Jeaspa Bandsaw

Memo
CUT BLANK 1.450" LONG

0.00

Cut @ meter

110 0.00



HAAS 1
HAAS CNC vertical machine #1

Memo
MACHINE AS PER FOLIO FA865 AND DWG
FOLIO REV: _____
DWG REV: _____

0.00

DEBURR

Purchasing

issue P/O: to meter P/O: 13000
Machine as per dwg D3910 Rev. B

C2 10/11/24 20

Work Order ID 64106

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Page 2

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 11/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC *rec'd*
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

receive + inspect for transit damage.
Memo

0.00

4/4/29 *(20)*

130



QC
Quality Control

QC6 Inspect parts - second check

0.00

Memo

0.00

Scrub/30

count
(x70)

140



HandFinish
Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

7/11 10/11/30

x20

0

November 24, 2010 12:43:00 PM

Abstract

REFERENCES

[illegible]

Abstract

Abstract

SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Abstract

M. 115951 START. 2:00

Memo

¹⁰OVEN T. 370

Finish 2:30.

$\Rightarrow 10 \mid 11 \mid 30$

00000000000000000000

QC

Memo

Quality Control

12/11/30 5200

Abstract

Packaging

Memo

Packaging

Work Order ID 64106

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Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 11/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/01

BS 10-12-1
(20)

Picklist Print

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Page 1

Work Order ID: 64106



Parent Item: D3910-1



Parent Item Name: Crosstube Lug

Start Date: 11/24/10

Required Date: 11/30/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			100	f	291.6744	0.13	2.736842			
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Lug Extrusion



CY 10/11/25

Location

Loc Qty

Loc Code

MAT06

291.6744265

43722

180

45800

111.674426

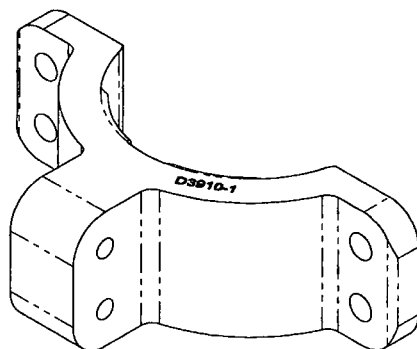
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D3910-1P

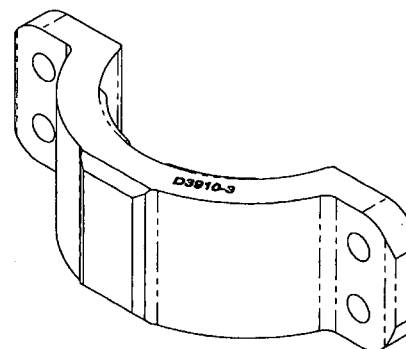
x20

CY 10/12/10 (20)

C210111124
w/o: 641104



D3910-1 X-TUBE LUG






D3910-3 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

RELEASED
2010-03-22
ND

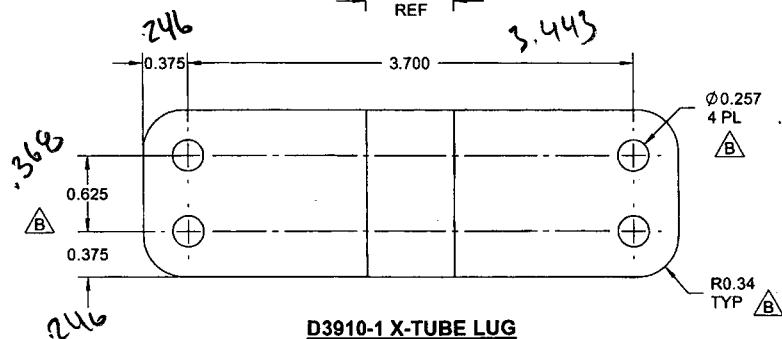
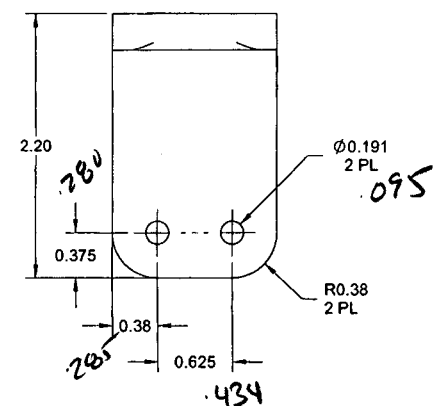
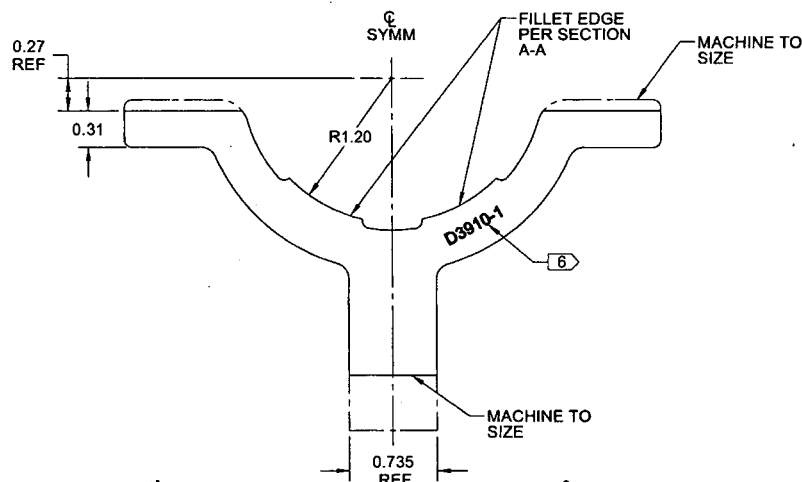
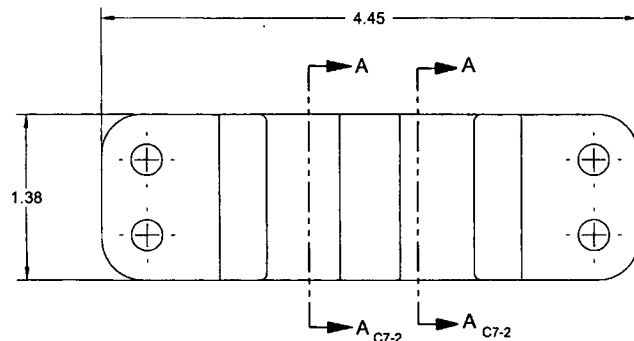
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-007-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2

REFERENCE ONLY



D3910-1 X-TUBE LUG

RELEASED
2010-03-22

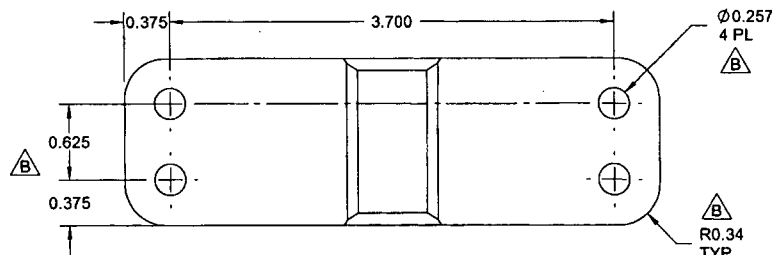
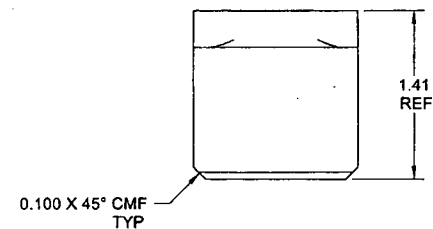
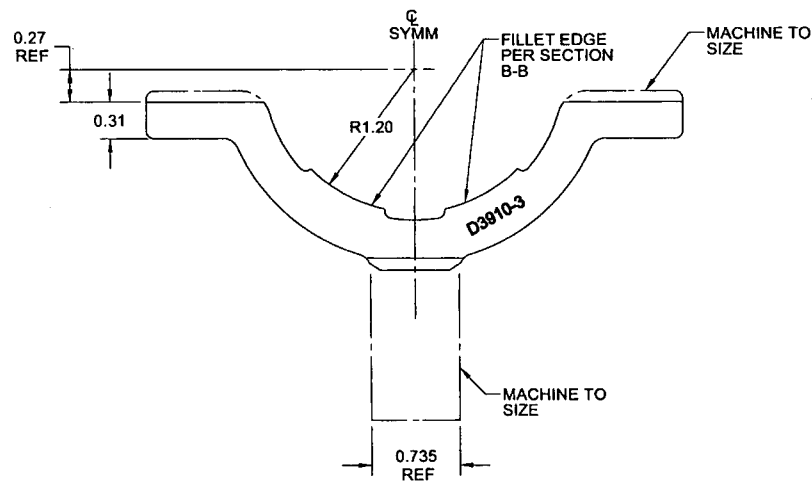
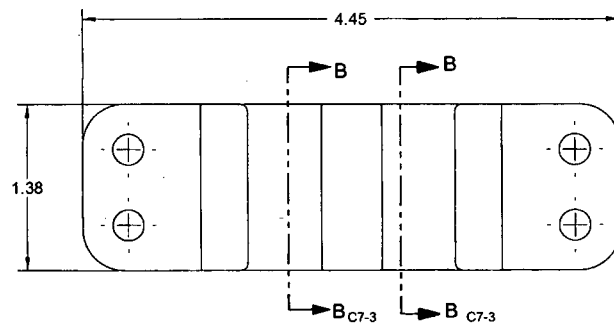
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3

REFERENCE ONLY



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13000

Purchase Order Date 11/24/10

PO Print Date 11/24/10

Page Number 1 of 2

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-3P	Crosstube Lug	11/29/10 Yes	30.00 Each		\$31.5500	\$946.50
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B63333 REQUIRED ASAP PLEASE RUSH ORDER				
2	D3910-1P	CROSSTUBE LUG	12/01/10 Yes	20.00 Each		\$31.5500	\$631.00
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B64016				
3	D2230-1P	LUG	12/06/10 Yes	60.00 Each		\$18.9500	\$1,137.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B63319				
4	D2230-3P	LUG	12/08/10 Yes	60.00 Each		\$10.4000	\$624.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/24/10



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

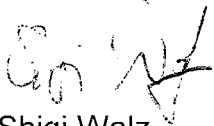
<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	D3910-3	Crosstube Lug	13000
20	D3910-1	Crosstube Lug	13000

8/10/9/30

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, November 29, 2010